

Date: Thursday, 9/21/2006 3:12:43 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OH-58 FWD X-TUBE ASSEMBLY
Job Number	: 28676		
Estimate Number	: 12526		
P.O. Number	: <i>N/A</i>	Part Number	: D058676101
This Issue	: 9/21/2006	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D058-676-141 REV A2
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 28675	Drawing Revision	: A2
		Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 10/10/2006
Checked & Approved By	: <i>[Signature]</i> 06.09.21	Qty:	1 Um: Each
Comment	: Est Rev:E 06.09.11 Reformat IEC		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D058-676-141 CHG001

-101

KS 06.09.21

2.0

D6001105

Crosstube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6001-105 Crosstube 23965

MS 06/09/21

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs on both ends as per Folio FA085

2-Turn first side as per Folio FA085

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D058-676-141. MS 06/09/22 1

4.0

QC1

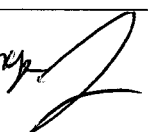
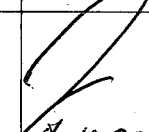
INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 06/09/22 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/10/30	1.0	Tube is A-101, not -201. Perm. Change 					 06/10/30

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 FWD X-TUBE ASSEMBLY

Job Number: 28676

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA085

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D058-676-141. *M8 06/09/22 1*

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

*M8 06/09/22 1*

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*J-G 06/09/25 1*

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Polish entire outside surface of crosstube ~~\*Done At Seq. 130~~ *PM 06-9-25 ①*

2-Remove sand and plugs *M8 06/09/22*

3-Scribe part # and batch # using vibrating stylus as per Dwg D058-676-141  
Inside of Cuff (Donot engrave on outside of tube)

*M8 06/09/22*

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*a.m 06-09-26 ①*

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*DP 6-9-27*

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D058-676-241 using CNC bender program OH58-fw and Folio FT014

*DP 6-9-27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Drawing Name: OH-58 FWD X-TUBE ASSEMBLY

Job Number: 28676

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC6

DIMENSIONAL CHECK



*06/10/03 ①*



Comment: Inspect dimensions and work To Current Step

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D058-676-141 using drill Jig DT8541 & DT8542.

2-Ream hole to finish size in tube as per Dwg D058-676-141 using drill Jig DT8541 & DT8542. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D058-676-141

*RT 06-10-03*

*06-10-03*

14.0

HAND FINISHING 1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*FC 06 10 05 ①*

15.0

QC5

INSPECT WORK TO CURRENT STEP



*06/10/05*



Comment: INSPECT WORK TO CURRENT STEP

16.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 0380

Issue P/O: *2186*

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

*06/10/05 ①*

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

*06/10/10 ①*

18.0

QC6

DIMENSIONAL CHECK



*06-10-10 ①*



Comment: Inspect for damage & ensure results are as per Dwg D058-676-241

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number: 28676

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

FC/M

06 10 25

(1)

2-Paint outside crosstube with White Imron as per QSI 005 4.2

M

06 10 25

(1)

20.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

Job 10-26 (1)

21.0

D2856400

Abrasion Strip



Comment: Qty.: 0.5800 f(s)/Unit Total : 0.5800 f(s)

Pick:

Qty Part number

Description

Batch

2 D2856-400-694 Abrasion Strip

B28250

RT

06-10-30

22.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description

Batch

2 D2891-1

Support

B28792

RT

06-10-30

23.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number

Description

Batch

4 MS21920-20

Clamp

M102440

RT

06-10-30

24.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579

2-Install supports and clamps as per Dwg D058-676-141. Torque clamps to 80-100 in lb.

2 RT 06-10-30

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Thursday, 9/21/2006 3:12:44 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 FWD X-TUBE ASSEMBLY

Job Number: 28676

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*06.10.30*  
*NOG/10/30 ①*

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

27.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

4 AN5-32A

Description Batch

Bolt

*SOA 14 31450*  
*M102238*

28.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part number

8 AN960JD516

Description Batch

Washer

*M102328*

29.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

4 MS21042L5

Description Batch

Nut (or -5)

*M101648*

*NOG/10/31 ①*

30.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*NOG/10/31 ①*

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D058-676-101

Location:

*OK*  
*NOG/10/31 ①*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 29 Date: 06/10/21  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 FWD X-TUBE ASSEMBLY

Job Number: 28676

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SP 06/10/31 (1)

Job Completion



u 26/10/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

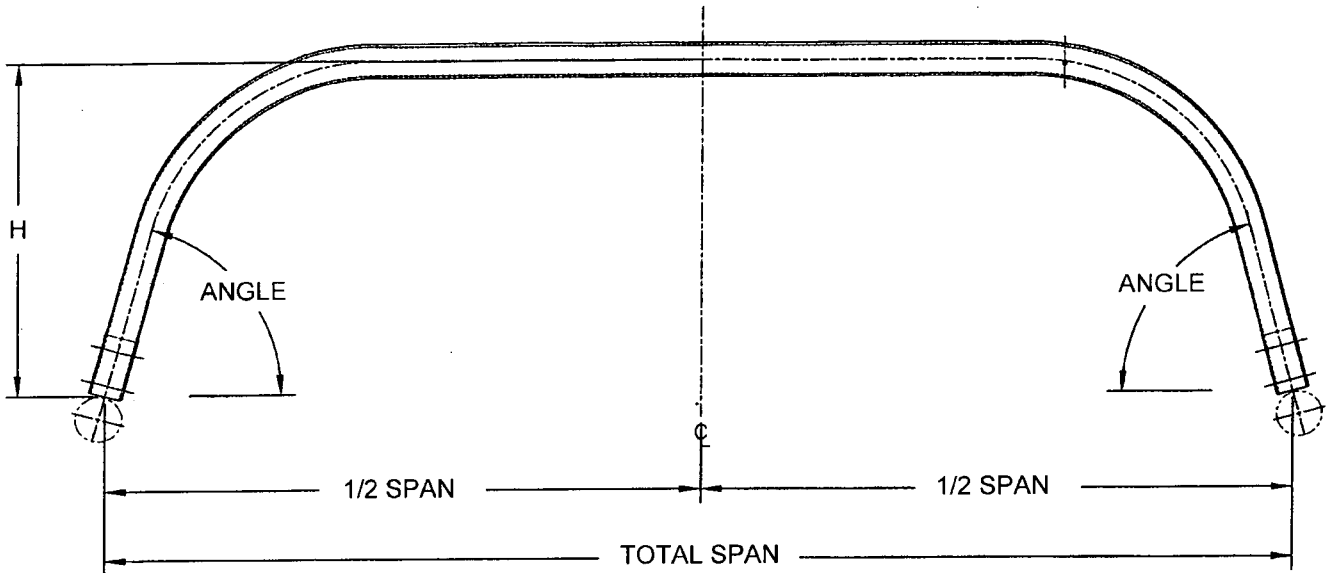
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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Crosstube Bend Dimension Sheet



DESCRIPTION: \_\_\_\_\_

BATCH NUMBER: 28676

DRAWING: \_\_\_\_\_ REVISION: \_\_\_\_\_

H: \_\_\_\_\_

1/2 SPAN: \_\_\_\_\_

TOTAL SPAN: \_\_\_\_\_

ANGLE: \_\_\_\_\_

QC-15: \_\_\_\_\_

DATE: \_\_\_\_\_

QTY: \_\_\_\_\_



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D058-676-141	REV. A SHEET 1 OF 3
DATE 00.11.17		TITLE CROSSTUBE ASS'Y (OH-58 HIGH FWD) NTS	
A	00.11.17	NEW ISSUE	

Qty	Part Number	Description
X	D058-676-141	CROSSTUBE ASSEMBLY (OH-58 HIGH FWD)
1	D6001-105	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
4	MS21920-20	CLAMP

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6001-105  
FINISHED LENGTH = 103.03±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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WITHOUT NOTICE

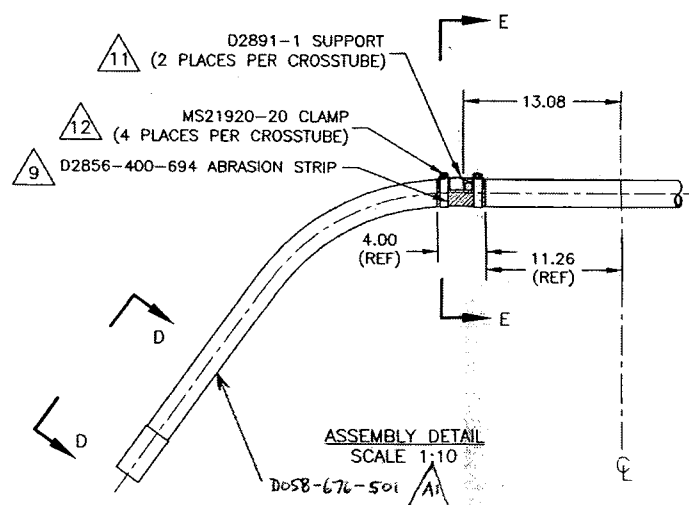
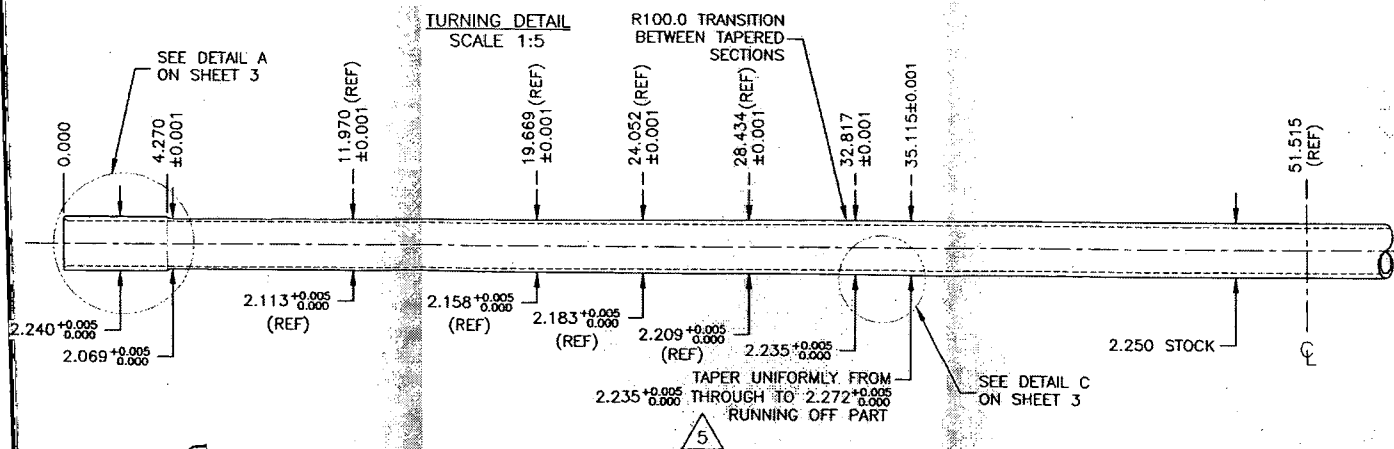
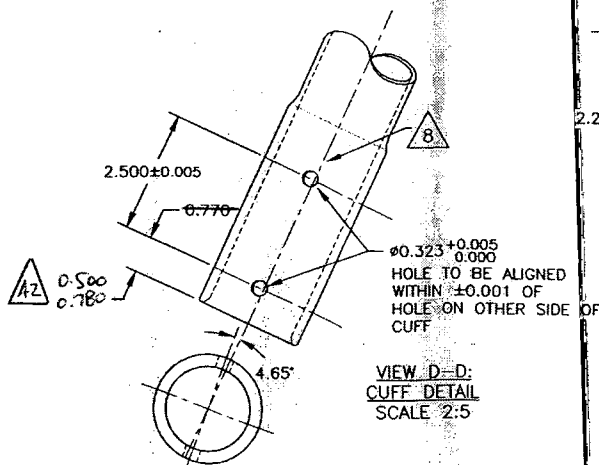
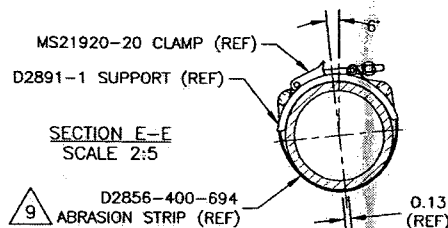
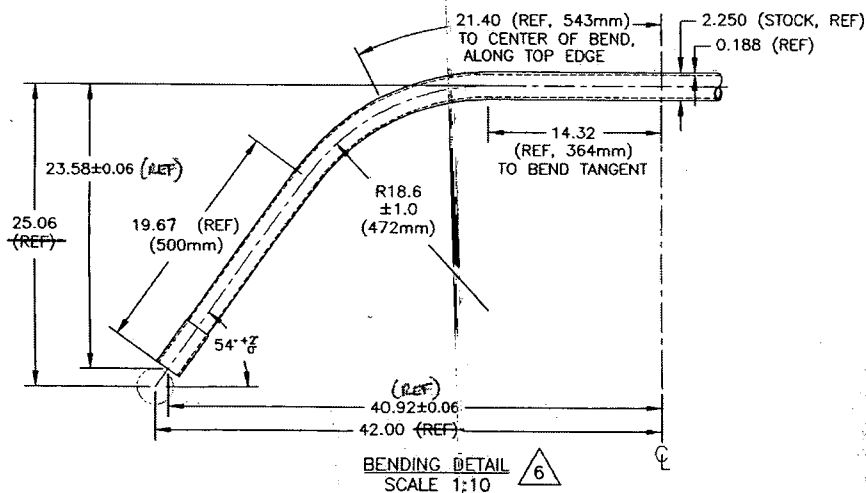
WORK ORDER  
NO. *28676*

RELEASED  
00.11.24 *#*

A2	01.07.16	UPDATE Dim TO FIRST HOLE	<i># CP</i>
A1	01.03.07	ADD D058-676-501 P/N	<i># CP</i>

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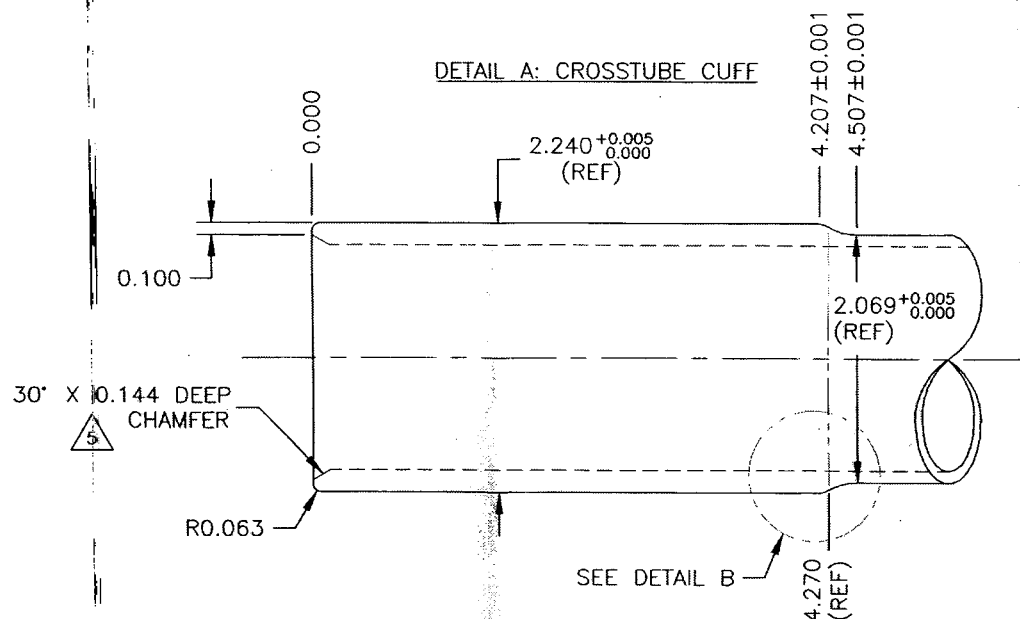
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WORK ORDER  
NO. 28676

RELEASED  
00.11.24

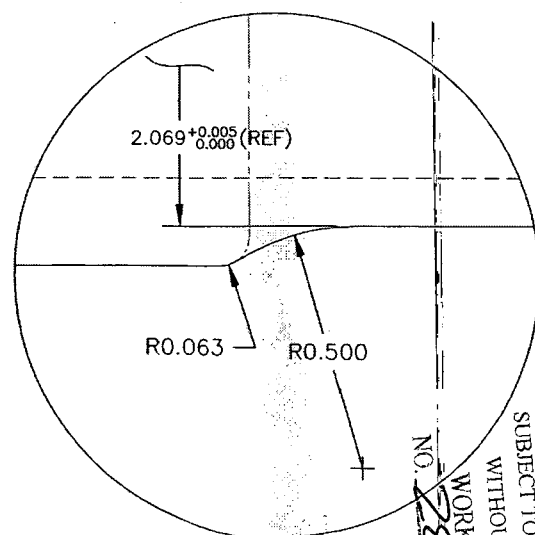
COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN CP	DRAWN BY CP	<b>DART</b>	DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, CANADA
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DATE 00.11.17		TITLE CROSSTUBE ASSEMBLY (OH-58 HIGH FW)		SCALE 1:10	

RELEASED  
00.11.24

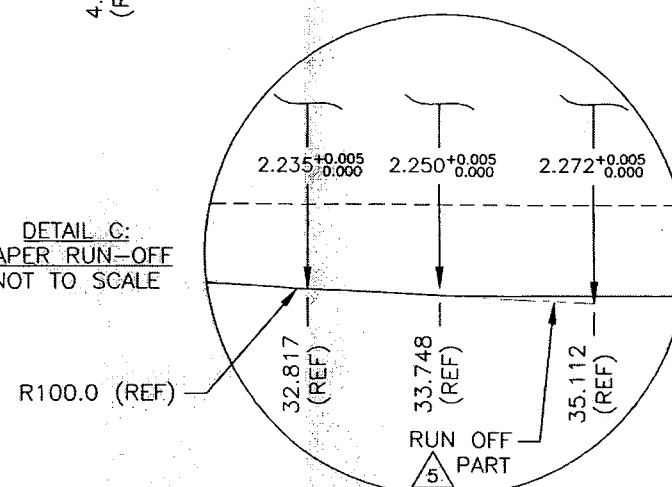
DETAIL A: CROSSTUBE CUFF



DETAIL B:  
CUFF TRANSITION  
SCALE 4:1



DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE



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NO. 286716

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		DATE 00.11.17	TITLE CROSSTUBE ASSEMBLY (CH-53 HIGH FWD)		SCALE 1:1



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 28676
<b>Description:</b> Crosstube assembly		<b>Part Number:</b> DOHSE-616-141
<b>Inspection Dwg:</b> DOHSE-616-141 Rev: A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

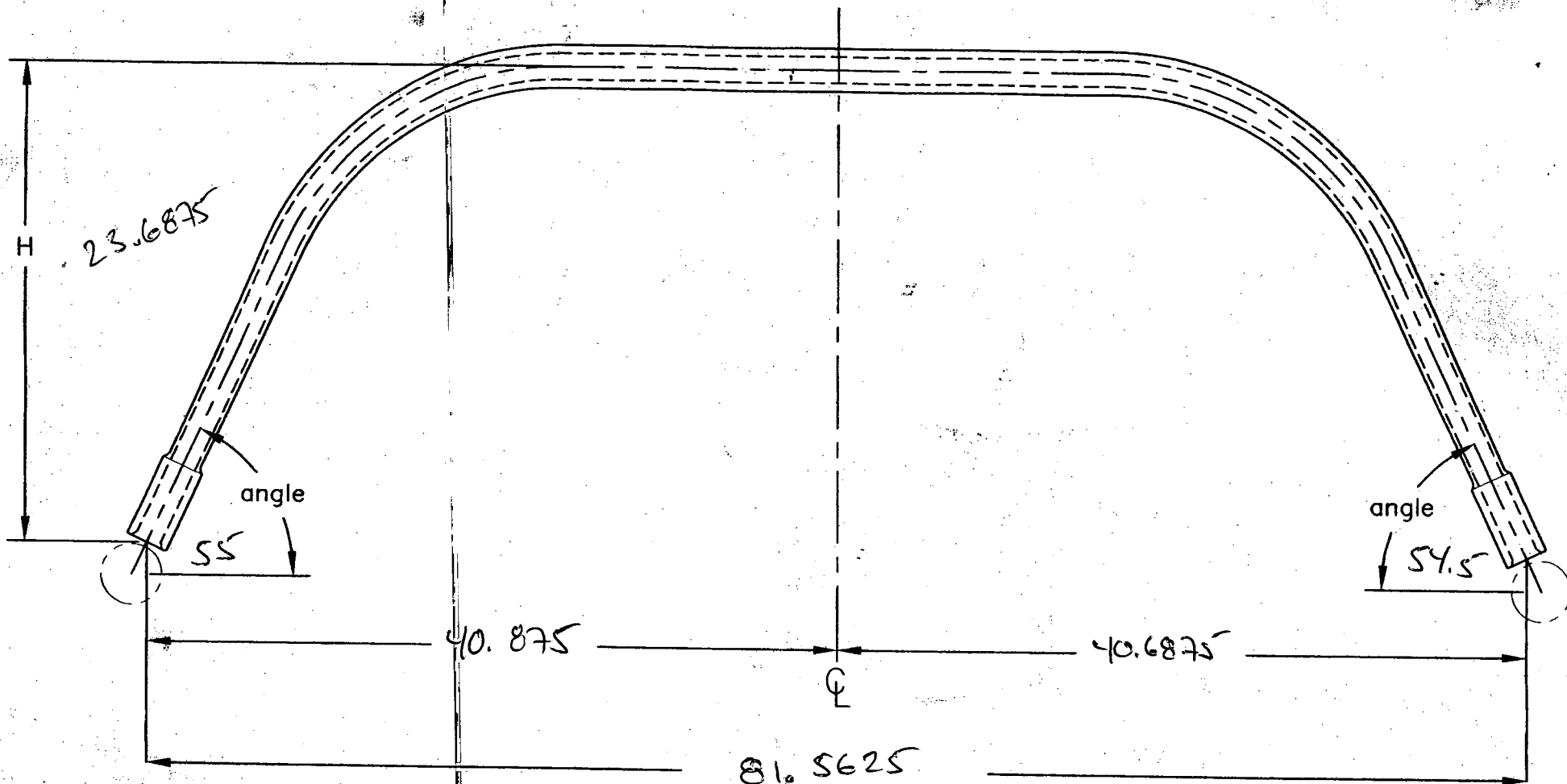
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.207	±.001	4.207	✓			
.100	±.010	.100	✓			
.063	±.010	.063	✓			
2.240	±.005 -0.000	2.244	✓			
2.069	"	2.073	✓			
2.113	"	2.118	✓			
2.158	"	2.162	✓			
2.183	"	2.187	✓			
2.209	"	2.214	✓			
2.235	"	2.239	✓			
4.207	±.001	4.207	✓			
.100	±.010	.100	✓			
.063	±.010	.063	✓			
2.240	±.005 -0.000	2.245	✓			
2.069	"	2.073	✓			
2.113	"	2.118	✓			
2.158	"	2.162	✓			
2.183	"	2.187	✓			
2.209	"	2.213	✓			
2.235	"	2.239	✓			
103.03	±.020	103.03	✓			

<b>Measured by:</b> MB
<b>Date:</b> 06/09/22

<b>Audited by:</b> J.G
<b>Date:</b> 06/09/25

<b>Prototype Approval:</b>
<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



DATE: 06.10.03

DESCRIPTION: DOSB-676-101

BATCH NO: B28676

DRAWING: DOSB-676-141 Rev. A

H: 23.58 }  $\pm .060$

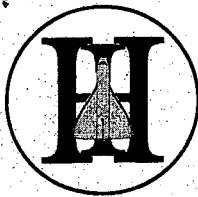
1/2 SPAN: 40.92

TOTAL SPAN: 81.84

ANGLE: 54  $\pm .0$

*[Signature]*

*[Signature]*  
 Fits table Fig.  
 A-1.



# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 34996

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

### INSPECTION REQUIREMENTS

Carry out FPI of six (6) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (4) P/N D058-676-101

S/N's B28676, B28675, B28660 & B28467

Qty. (2) P/N D058-676-201

S/N's B28768 & B28765



RADIOGRAPHY



ULTRASONIC



PENETRANT



MAGNETIC PARTICLE



EDDY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on six (6) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)  
Ardrox 970P25E Batch #04B503.

Six (6) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: 

DATE

October 6, 2006

INSPECTION  
STAMP(S)

Not Required

### CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

00002186

ADDRESS:

CONTACT NAME:

LABOUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

@

PST

INVOICE NO.

TOTAL \$